



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6305G00232-3G

Job Sheet 186957



Part No: RBW6305G00232-3G

Job Qty: 1 ea

Part Name: Gimbal Torque Tube Bushing Installer



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/23/18

Job Tracking No:

Due Date: 12/14/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6305G00232-3G Rev 2 IPP Rev A 18.02.21 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off	DAS
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time		
90	Start up Operation	1 Ea		12/14/18	0.00	0.00	Start Up Small Fab-4			30
100	Small Fab	1 pcs		12/14/18	0.00	0.17	Small Fab-9		M.L.	9-89
110	QC	1 pcs		12/14/18	0.00	0.00	QC5			30
120	QC	1 pcs		12/14/18	0.00	0.00				9-89
130	Packaging	1 pcs		12/14/18	0.00	0.00	Packaging3-2			
140	QC21-FG	1 Ea		12/14/18	0.00	0.00	QC21			

Part Op 100 - Assemble as per DWG.
Descriptions: 130 - Identify and Stock

21 DEC 11 2018
9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW6305G00232-3G-1	Base	1 Ea (1 ea)	90-Start up Operation	5092778
RBW6305G00232-3G-3	Guide	1 Ea (1 ea)	90-Start up Operation	5052889
RBW6305G00232-3G-5	Stop	1 Ea (1 ea)	90-Start up Operation	5082860
RBW6305G00232-3G-7	Stud	1 Ea (1 ea)	90-Start up Operation	5089953
AN315-6R	3/8"-24 RH Threaded Nut	1 Ea (1 ea)	90-Start up Operation	5048298
NAS1149F0632P	Washer	1 Ea (1 ea)	90-Start up Operation	5048297

Job Allocations

Operatic	red	Inventory	Allocated
90-Start		276	0
		318	0
		25	0
		3	0
		12	0
		11	0

Container No: S136425



Part: RBW6305G00232-3G

Job No: 186957

Serial No/Batch: S136425

Revision: 2

Inspector:

Exp Date:

Instructions:

Date: 12/10/18

Plex 11/23/18 9:24 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

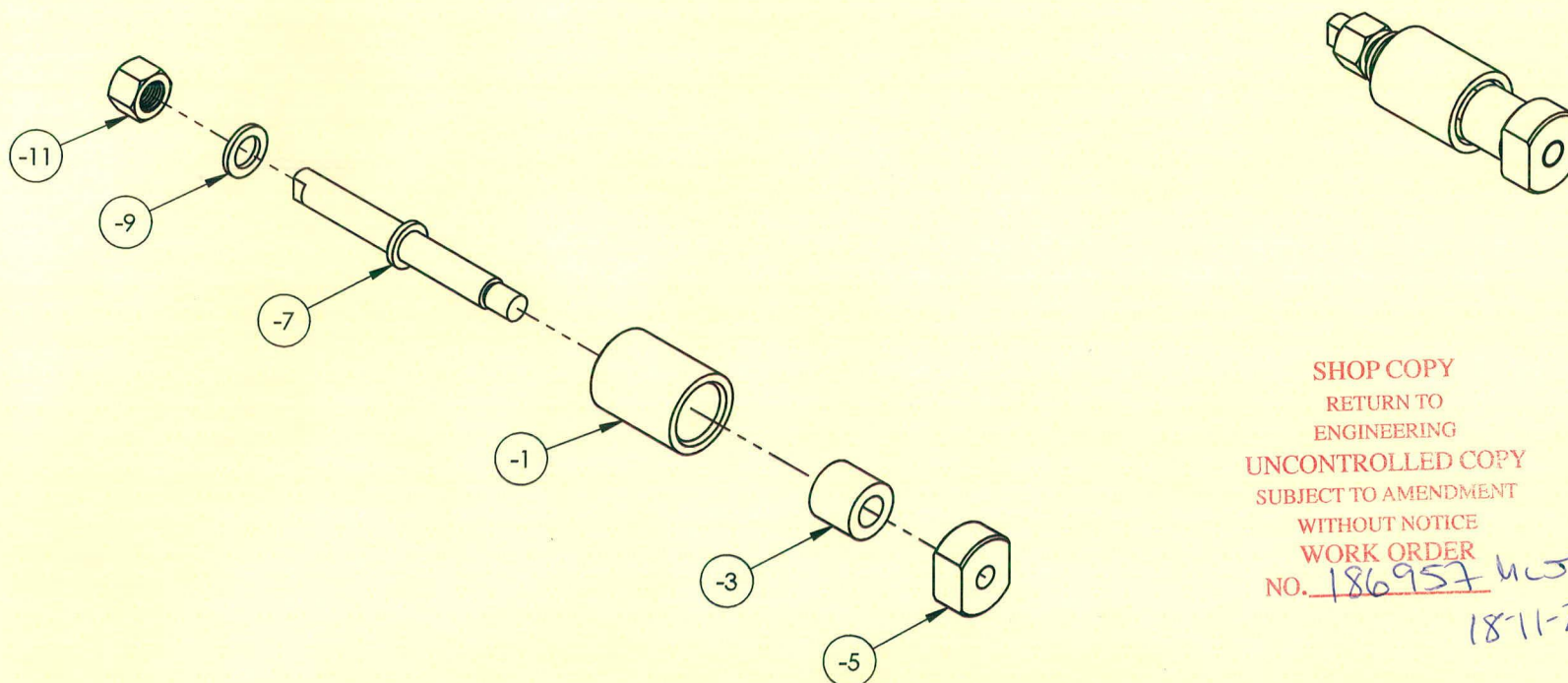
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
										QC / QA Coordinator Approval															
Root Cause		FAULT CATEGORY																							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
A		BROKE OUT INTO INDIVIDUAL TOOL FROM KIT RBW6305G00132-3G.	4/7/2011	RJC	
1		-3 CH'D I.D. ADDED TOLERANCE WAS $\varnothing.379$ IS $\varnothing.375 +.005 -.000$. -7 CH'D O.D. ADDED TOLERANCE WAS $\varnothing.375$ IS $\varnothing.370 +.000 -.005$.	5/3/2013	CFS	GE
2	15-0292	-1, -3, -5 CH'D MATERIAL CALL OUT WAS 4140 Q&T IS 4140 Q&T / 4142 Q&T. -7 CH'D MATERIAL CALL OUT WAS 4140 Q&T IS 4140 Q&T / 4142 Q&T. CH'D DIM WAS $\varnothing.317$ IS $\varnothing.315$, WAS .030 IS .05 WAS .040 IS .04.	9/10/2015	RJC	JAG



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 186957 *hcs*
18-11-23

NOTE:
ALSO SOLD WITH KIT RBW6305G00132-3G.

DART AEROSPACE	
TITLE GIMBAL TORQUE TUBE BUSHING INSTALLER	
DWG NO. RBW6305G00232-3G	REV 2
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1	DRAWN BY: PERRITT APPROVED: <i>D Weil</i> HEAT TREAT FINISH SPEC USED ON MODEL AGUSTA
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	SCALE 1:1 DATE 4/7/2011 SHEET 1 OF 5

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	BASE	4140 Q&T / 4142 Q&T		2
			-3	1	GUIDE	4140 Q&T / 4142 Q&T		3
			-5	1	STOP	4140 Q&T / 4142 Q&T		4
			-7	1	STUD	4140 Q&T / 4142 Q&T		5
		B/O	-9	1	WASHER	STEEL	$\varnothing.378$ I.D. AN960-616L	1
		B/O	-11	1	HEX NUT	STEEL	3/8-24 UNF AN315-6	1

